

Work Order ID 65305

January 11, 2011 9:25:33 AM



Page 1

Item ID: K642-512

Accept



Setup Start



Revision ID:

Stop



Item Name: saddle kit 642-512

Start Date: 1/18/11 Start Qty: 3.00



Cust Item ID:

Required Date: 1/28/11 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9467

Rev A

IIN D206-642

Rev N

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

8/10/2010

Document Control

Create White labels per PPP K642-512 CHG004

OK for CL 11/02/10

110

Pick Kit

0.00



Packaging

Memo

0.00

Substrate

Packaging

10/02/2 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 11, 2011 9:25:16 AM

Page 1

Work Order ID: 65305

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 1/18/11

Required Date: 1/28/11

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 05.06.07 new issue EC
IPP Rev.B 05.02.08, Per ECN1080P

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C35A		Purchased	No			110	Each	61.0000	3	9			
---------	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--



BOLT

Location

Loc Qty

Loc Code

ST353

61

111724

1

114523

30

116082

30

AN3C36A

Purchased

No

110

Each

125.0000

9

27



BOLT

Location

Loc Qty

Loc Code

ST353

125

109771

6

116050

50

116381

69

AN3C41A

Purchased

No

110

Each

107.0000

8

24



BOLT

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

103

116050

3

116381

100

10

116082

27

1116050 11X

116381 16X

11/24 (3)

116381

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 65305

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 1/18/11

Required Date: 1/28/11

Start Qty: 3.00

Required Qty: 3.00

AN4C6A

Purchased

No

110

Each

331.0000

12 136



Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

327

113121

1

115016

76

116003

200

116400

50

115016 24x
116003 15x

AN5C11A

Purchased

No

110

Each

165.0000

8



Bolt

Location

Loc Qty

Loc Code

FG

3

104817

3

ST338

162

114443

14

114455

48

116075

50

116381

50

m114408

AN5C12A

Purchased

No

110

Each

88.0000

4



BOLT

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

86

113121

42

116075

44

m116075

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 65305

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 1/18/11

Required Date: 1/28/11

Start Qty: 3.00

Required Qty: 3.00

AN5C13A

Purchased

No

110

Each

106.0000

4

12



BOLT

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

104

114615

4

116075

100

AN5C15A

Purchased

No

110

Each

54.0000

1

3



Bolt

Location

Loc Qty

Loc Code

ST339

54

111819

54

AN5C32A

Purchased

No

110

Each

104.0000

2

16



Location

Loc Qty

Loc Code

FG

4

18918

4

ST340

100

113164

50

116380

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 65305

Parent Item: K642-512


Parent Item Name: saddle kit 642-512

Start Date: 1/18/11

Required Date: 1/28/11



Start Qty: 3.00

Required Qty: 3.00

SF3 AN5C34A Purchased No 110 Each 66.0000 2 16  


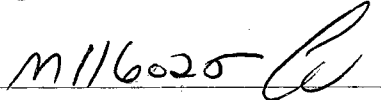
Location Loc Qty Loc Code

FG 2
18918 2
ST340 64
111648 4
112454 60

SF3 AN5C35A Purchased No 110 Each 74.0000 1  


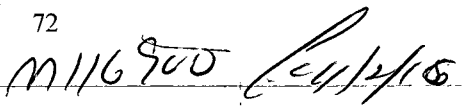
Location Loc Qty Loc Code

ST340 74
108084 28
108407 46

SF3 AN960C10L washer NAS1149C0332 R Purchased No 110 Each 25.0000 24 72  

Location Loc Qty Loc Code

ST245 25
107534 25

SF3 AN960C416L WASHER NA01149C0432R Purchased No 110 Each 19.0000 24 72   (3)

Location Loc Qty Loc Code

ST346 19
112828 19

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 65305

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 1/18/11

Required Date: 1/28/11

Start Qty: 3.00

Required Qty: 3.00



AN960C516L NAS1149C0532 Purchased No

110 Each 6.0000 8 .24



WASHER



11/16289

[Handwritten signature]

Location

Loc Qty

Loc Code

ST347

6

111916

6

D206-648-013 CHG002 Manufactured No

110 Each 3.0000 1 3



GHW Modification



65478

[Handwritten signature]

Location

Loc Qty

Loc Code

FG120

3

64307

1

64699

2

D2652 Manufactured No

110 Each 452.0000 16 48



Bushing



64422 (3)

Location

Loc Qty

Loc Code

FG

44

31985

44

ST020

408

61645

1

64267

198

64770

103

65049

106

64267

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 65305

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 1/18/11

Required Date: 1/28/11

Start Qty: 3.00

Required Qty: 3.00

D2712 Manufactured No

110 Each 468.0000 10 30



Set Screw

Location Loc Qty Loc Code

FG	50	
29962	50	
ST021	250	
65115	250	
ST022	168	
61331	168	

D2932-2 Manufactured No

110 Each 9.0000 1



Saddle RH Out, 206

Location Loc Qty Loc Code

ST421	1	
62637	1	
ST428	2	
60253	2	
ST428A	6	
62080	6	

D2933-2 Manufactured No

110 Each 6.0000 1



Saddle RH In, 206

Location Loc Qty Loc Code

ST428	6	
63585	6	

61331
3 ✓

65283 14
62080 24

63585

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 65305

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 1/18/11

Required Date: 1/28/11

Start Qty: 3.00

Required Qty: 3.00

D2934

Manufactured No

110

Each

21.0000

2

6



Saddle Spacer



66043 1x

Location

Loc Qty

Loc Code

FG

6

31929

6

ST028

15

63559

15

Manufactured No

110

Each

39.0000

2

6

D2935



Saddle Spacer



63559 5x

Location

Loc Qty

Loc Code

ST028

39

62690

13

63558

26

Manufactured No

110

Each

2.0000

1

3

D2938-2



Saddle RH Out, 206



62690 3x
63558 3x
B66035

Location

Loc Qty

Loc Code

ST428A

2

63590

2

Manufactured No

110

Each

5.0000

1

3

D2939-2



Saddle RH In, 206



63590 1x
13
641022 (3)

Location

Loc Qty

Loc Code

ST428A

5

58268

1

63586

4

63586

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 65305

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 1/18/11

Required Date: 1/28/11

Start Qty: 3.00

Required Qty: 3.00

D3396-3

Manufactured No

110 Each

29.0000

- 2

16



Spacer

Location

Loc Qty

Loc Code

FG

10

26772

10

ST055

19

58680

1

63557

18

D3407-043

Manufactured No

110 Each

4.0000

1

3



Tow Ring

Location

Loc Qty

Loc Code

ST420

3

62627

3

ST464

1

50387

1

D3456-1

Manufactured No

110 Each

112.0000

1

3



Washer

Location

Loc Qty

Loc Code

ST058

112

63239

12

64282

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 65305

Parent Item: K642-512

Parent Item Name: saddle kit 642-512

Start Date: 1/18/11

Required Date: 1/28/11

Start Qty: 3.00

Required Qty: 3.00

D3457-1

Manufactured No

110

Each

15.0000

2

6

Washer

Location

Loc Qty

Loc Code

FG

10

32409

10

ST059

5

45913

1

62691

4

D3672-1

Manufactured No

110

Each

1,309.000

24

72

Phenolic Washer

Location

Loc Qty

Loc Code

ST077

1309

42329

10

52505

299

64177

1000

D3672-3

Manufactured No

110

Each

1,039.000

24

72

Phenolic Washer

Location

Loc Qty

Loc Code

ST077

1039

57704

39

64176

1000

D3672-7

Manufactured No

110

Each

1,100.000

24

72

Phenolic Washer

Location

Loc Qty

Loc Code

ST077

1100

53237

244

64175

856

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 65305

Parent Item: K642-512

Parent Item Name: saddle kit 642-512



Start Date: 1/18/11

Required Date: 1/28/11

Start Qty: 3.00

Required Qty: 3.00

MS21043-3

Purchased

No

110

Each

1,711.000

20

60



Nut

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

1635

112314

1635

MS21043-4

Purchased

No

110

Each

1,195.000

13



Nut

Location

Loc Qty

Loc Code

ST301

1195

114523

5

114784

2

115936

292

116188

596

116549

300

MS21043-5

Purchased

No

110

Each

588.0000

4

12



Nut

Location

Loc Qty

Loc Code

ST300

100

116548

100

ST301

488

112314

488

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE USA, INC.

D206-642

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4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

Item	Qty -511	Qty -512	Qty -541	Qty -547	Qty -013	Part Number	Description
	X					D206-642-511	SKIDTUBE INSTALLATION, LH
		X				D206-642-512	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-541	SKIDTUBE
				X		D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D3274-041	SKIDTUBE ASSEMBLY
3			1			D2646	* AFT CAP ⁽¹⁾
4			2			AN3C4A	* BOLT ⁽¹⁾
5A			2			AN960C10L	* WASHER ⁽¹⁾
5B			2			D3672-1	* WASHER (REPLACES NAS1515H3L) ⁽¹⁾
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3C41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21043-3	NUT
12B	16	16				D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4				AN5C11A (or AN5C12A)	* BOLT ⁽²⁾
14	4	4				AN5C11A (or AN5C13A)	* BOLT ⁽²⁾
15A	8	8				AN960C516L	WASHER
15B	8	8				D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12				AN4C6A	BOLT
17A	24	24				D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24				AN960C416L	WASHER
18	12	12				MS21043-4	NUT
20A			9	9		D3537-1	* WEARPAD ⁽¹⁾ (REPLACES D2648-3)
21A			1	1		D3537-3	* WEARPAD ⁽¹⁾ (REPLACES D3429-1)
22A			1	1		D3535-15	* WEARSHOE ⁽¹⁾ (REPLACES D2656-15)
22B			1	1		D3536-15	* GASKET ⁽¹⁾
23A			1	1		D3535-23	* WEARSHOE ⁽¹⁾ (REPLACES D2656-23)
23B			1	1		D3536-23	* GASKET ⁽¹⁾
24A			1	1		D3535-39	* WEARSHOE ⁽¹⁾ (REPLACES D3287-1)
24B			1	1		D3536-39	* GASKET ⁽¹⁾
25A			1	1		D3535-35	* WEARSHOE ⁽¹⁾ (REPLACES D2656-35)
25B			1	1		D3536-35	* GASKET ⁽¹⁾
26A			78	78		AN3C4A	* BOLT ⁽¹⁾
26B			78	78		AN960C10L	* WASHER ⁽¹⁾
26C			78			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING
32A	1	1				D3456-1	WASHER
32B	2	2				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34			1			AN4C5A	BOLT
35			1			AN960C416	WASHER
36			1			D3413-1	RING
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER

continued on next page...

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Revision: N

Date: 09.09.09

continued from previous page...

ITEM	QTY -511	QTY -512	QTY -541	QTY -547	QTY -013	PART NUMBER	DESCRIPTION
40					2	D3414-041	LUG ASSEMBLY (GHW)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER
50	9	9				AN3C36A	BOLT
51	3	3				AN3C35A	BOLT
52	24	24				AN960C10L	WASHER
53	24	24				D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12				MS21043-3	NUT
55	2	2				D3396-3	SPACER
56A	1	1				AN5C35A	BOLT
56B	1	1				AN5C15A	BOLT
60	2	2				AN5C32A	BOLT
61	2	2				AN5C34A	BOLT
62	4	4				MS21043-5	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 ASSEMBLY ABOVE
 (2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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Revision: **N**
 Date: 09.09.09